

Work Order ID 73927

Monday, September 19, 2011 12:47:14 PM



Page 1

Item ID: DSK080

Accept



Setup Start



Revision ID:

Stop



Item Name: D2896-1 TURNING DETAIL

Start Date: 9/19/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11/09/19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSK080

Rev A

100

0.00



MORI SEIKI CNC LATHE LARGE

Doosan

Memo

0.00

Doosan Lathe

Turn blank as per Folio FA167

Signature: [Handwritten Signature]
11/9/21

10 0

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Signature: [Handwritten Signature]
11/9/21

10 0

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

20 11.9.26

10 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73927

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Page 2

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Accept



Setup Start



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Start Date: 9/19/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and Stock in Kanban Location: CKC

Re 11-9-26

10

7

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

11/9/27 [Signature]

ME
11-09-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, September 19, 2011 12:47:31 PM

Page 1

Work Order ID: 73927



Parent Item: DSK080



Parent Item Name: D2896-1 TURNING DETAIL

Start Date: 9/19/2011

Required Date: 9/23/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6104-011

Manufactured

No

Each

10.0000

10



17-4 SS Roundbar 6.50"OD

SA 11/9/21

Location

Loc Qty

Loc Code

MAT047

10

73500

10

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	73927
Description: Turning Detail for D2896-1		Part Number:	DSK080
Inspection Dwg: DSK080	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.480	3.485		3.485	3.485	3.485	3.485	3.483
B	3.990	4.010		3.995	3.991	3.991	3.992	3.997
C	3.825	3.845		3.836	3.836	3.836	3.836	3.839
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.101	.101	.101	.101	.101
F	3.705	3.725		3.716	3.717	3.716	3.716	3.719
G	1.360	1.380		1.365	1.371	1.370	1.370	1.370
H	1.250	1.260		1.253	1.253	1.253	1.255	1.254
I	6.490	6.510		6.499	6.500	6.499	6.495	6.498
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.240	0.260		.260	.260	.260	.260	.260
L	0.107	0.127		.115	.116	.115	.116	.117
M								
N								
O								
P								

Measured by: SA 10ml	Date: 11/09/22
Audited by: 20	Date: 11.9.26
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DART AEROSPACE LTD		Work Order:	73927
Description: Turning Detail for D2896-1		Part Number:	DSK080
Inspection Dwg: DSK080		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	10
Lathe Section								
A	3.480	3.485		3.484	3.481	3.481	3.481	3.481
B	3.990	4.010		3.998	3.997	3.997	3.998	4.000
C	3.825	3.845		3.837	3.835	3.836	3.836	3.836
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.100	.101	.101	.100	.100
F	3.705	3.725		3.718	3.718	3.717	3.717	3.717
G	1.360	1.380		1.370	1.371	1.370	1.370	1.370
H	1.250	1.260		1.258	1.258	1.256	1.256	1.258
I	6.490	6.510		6.498	6.498	6.500	6.500	6.500
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.240	0.260		.260	.260	.260	.260	.260
L	0.107	0.127		.116	.118	.118	.119	.118
M								
N								
O								
P								

Measured by:	<i>SA 10m</i>	Date:	11/9/21
Audited by:	<i>PR</i>	Date:	11.9.22
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>

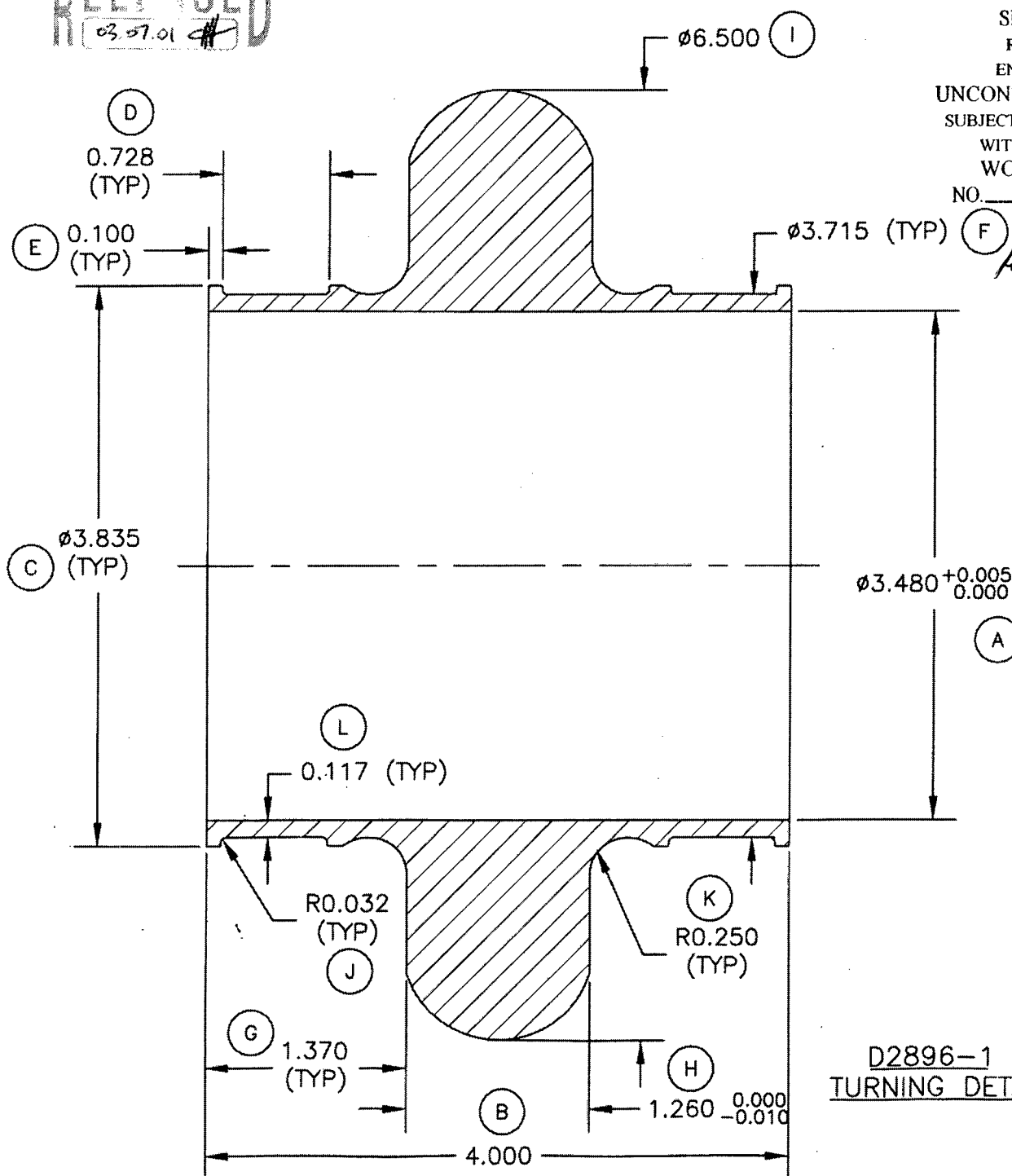


DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 080	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2896-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73927

11-09-15



D2896-1
TURNING DETAIL

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